

Work Order ID 151376***151376***

Page 1

Friday, September 23, 2016 2:48:59 PM

Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp
Start Date: 9/16/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: SEP 26 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								
D2727	A1								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.13							
FLOW CNC Waterjet	Cut as per dwg D2438 prog rev: <u>C</u> dwg rev: <u>C</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.07							
Quality Control	Ensure Material Release Note is attached								

Work Order ID 151376***151376***

Page 2

Friday, September 23, 2016 2:48:59 PM

Item ID: D2438

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 9/16/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.13							
Quality Control	(6.786" center to center)								
									DAS 38 9-89 SEP 27 2016
130		0.03							
130	Small Fab								
Small Fab	Memo	0.07							
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709								
									DAS 30 9-89 SEP 29 2016
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.13							
Quality Control									
									DAS 38 9-89 SEP 29 2016

Work Order ID 151376

Friday, September 23, 2016 2:48:59 PM

151376

Page 3

Item ID: D2438

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 9/16/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Identify as per dwg & Stock Location: 51542 0.00cont***150***

Packaging

Memo

0.07

Packaging

SEP 29 2016

DAS
6
9-89

160 QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.67

Quality Control

DAS
21
9-89

SEP 30 2016

DAS
21
9-89

SEP 30 2016

Picklist Print

Friday, September 23, 2016 2:48:58 PM

Page 1

Work Order ID: 151376

151376

Parent Item: D2438

D2438

Parent Item Name: Clamp

Start Date: 9/16/2016

Required Date: 9/23/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	143.7000	0.04	1.684212			

M304S16GA

2/16/09/26

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

143.7

m135377

46.8

m135559

32.9

m135689

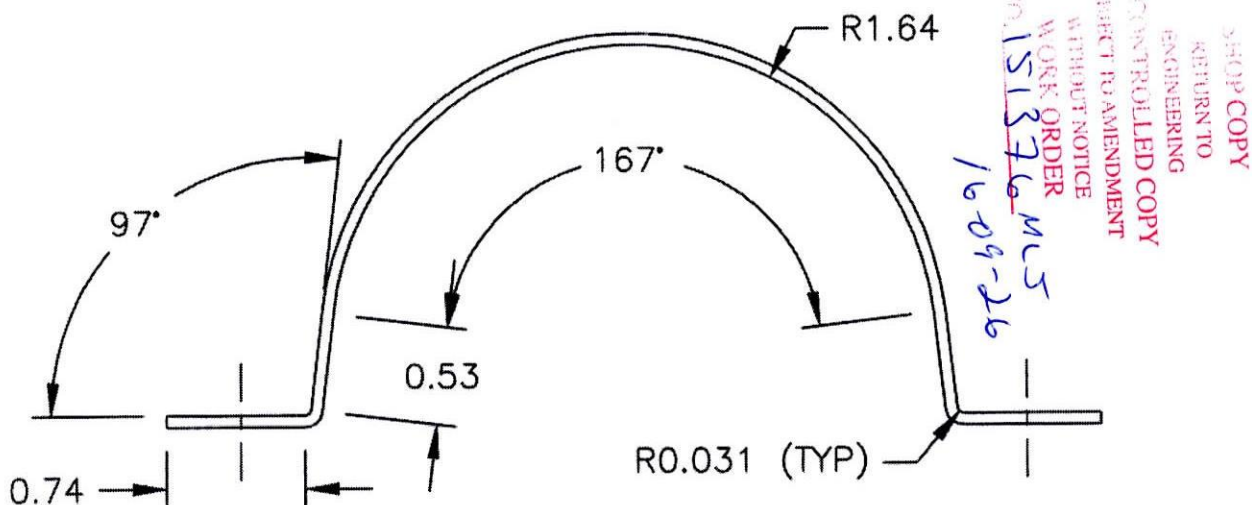
64

2

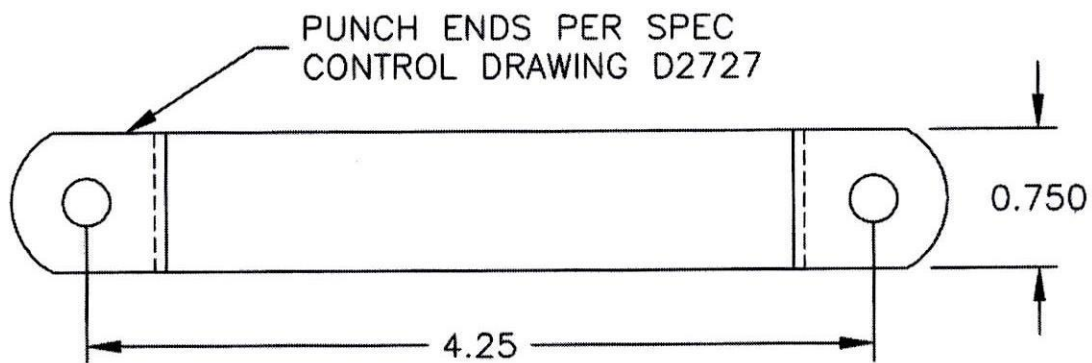


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
151376 MLS
16-09-26



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

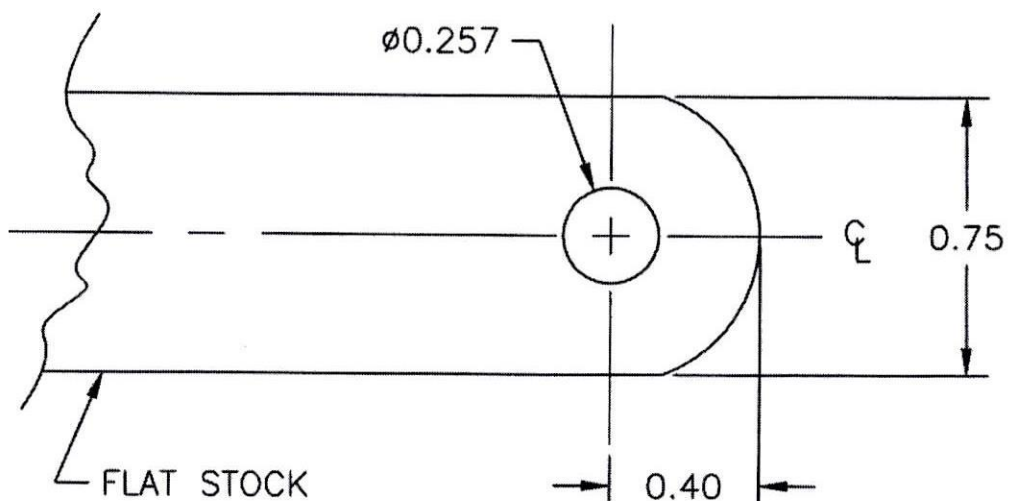
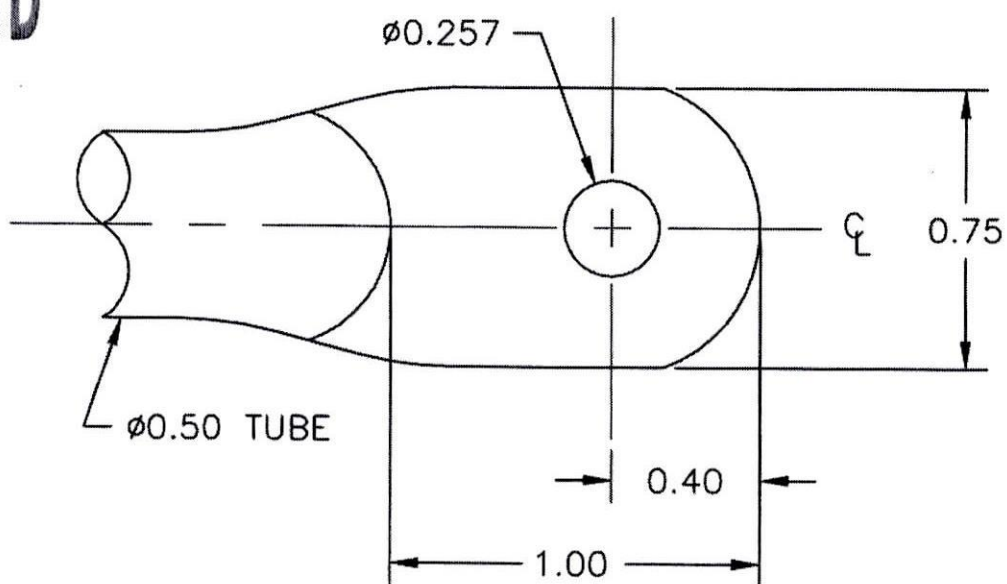
00.06.06
CP 00.06.07



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
AI	01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

